



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB877206-5-2
Job Sheet 195958



Part No: RB877206-5-2

Job Qty: 2 pcs

Part Name: Bearing Cutter Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877206-5 REV 4A IPP REV A 18.02.22 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	7/29/19		0.00	0.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	7/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	2 pcs	7/29/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS JUL 25 2019 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
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CANADA
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Container No: S199838



Part: RB877206-5-2

Job No: 195958

Serial No/Batch: S199838

Revision: 4A

Inspector:

Exp Date:

Instructions:

Date: 07/23/19

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

140 QC 21 - FG	2 pcs	7/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - (Small Fab) 1-Assemble as per DWG. Sheet 1.
Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location:) Bag and Tag
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
9657K393	Compression Spring	2 Ea (1 ea)	110-Small Fab - 1	5050270
DK-55	Knob	2 Ea (1 ea)	110-Small Fab - 1	5088955
NTA-512	Bearing	2 Ea (1 ea)	110-Small Fab - 1	5057540
RB877206-5-1	Shaft	2 pcs (1 ea)	110-Small Fab - 1	5196010
RB877206-5-3	Handle	2 pcs (1 ea)	110-Small Fab - 1	5134327
RB877206-5-7	Cutter	2 pcs (1 ea)	110-Small Fab - 1	5069925
TRA-512	Washer	4 Ea (2 ea)	110-Small Fab - 1	7K5093804
				1V507537

Job Allocations

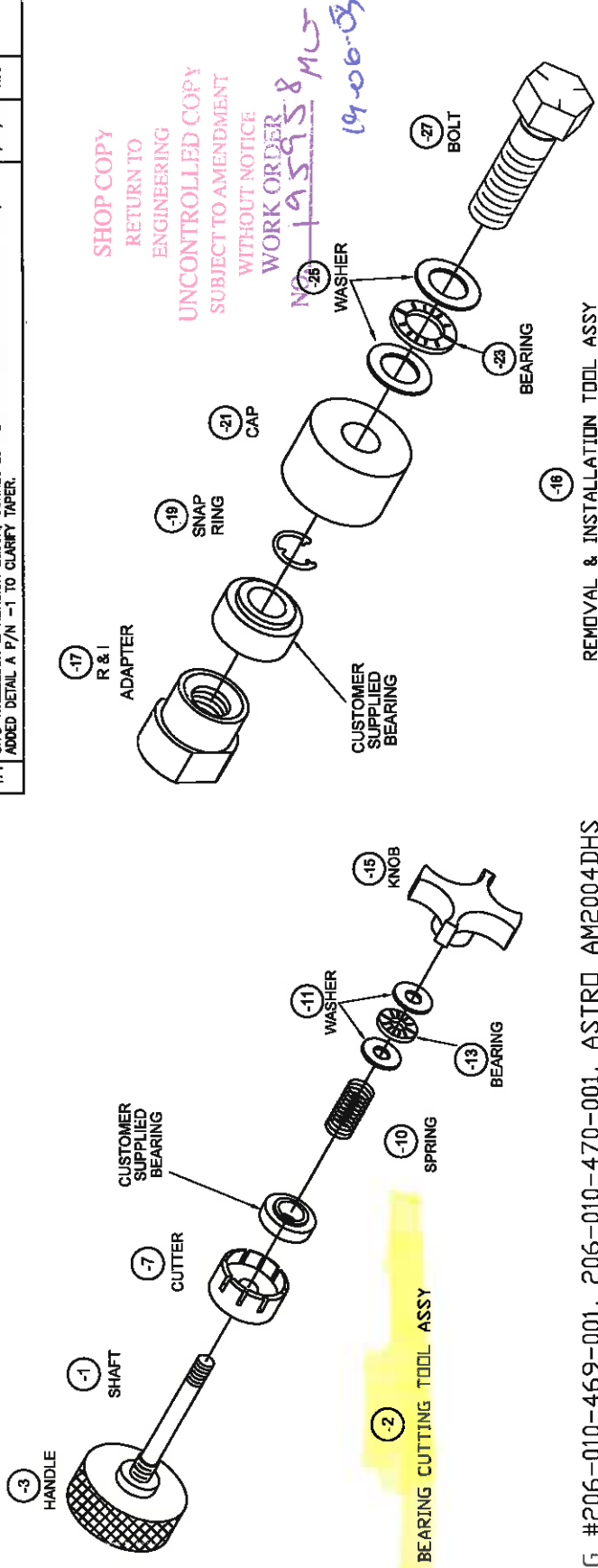
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	9657K393	2	12	0
	DK-55	2	9	0
	NTA-512	2	17	0
	RB877206-5-1	2	0	0
	RB877206-5-3	2	8	0
	RB877206-5-7	2	8	0
	TRA-512	4	33	0

Part Specifications
Specifications could not be found.

Plex 6/3/19 1:07 PM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04	
2	CH'D -7 PREGRIND TOLERANCE FROM .953.	1/2/08	WP G.E.
3	ADDED AM 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/28/08	WP DW
4	CH'D -27 GROOVE NOMENCLATURE FROM .032 W x .025 DP.	1/28/08	WP GE
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/28/09	RJC RW



NOTE: BEARING #206-010-469-001, 206-010-470-001, ASTRO AM2004DHS

REMOVAL & INSTALLATION TOOL ASSY

BIO INFORMATION OR SPECIFICATIONS		DESCRIPTION		MATERIAL		STRESS PROOF		BIO INFORMATION OR SPECIFICATIONS	
ASSY QTY	BIO PART #	UNIT QTY	DESCRIPTION	MATERIAL	STRESS PROOF	ASSY QTY	BIO PART #	UNIT QTY	DESCRIPTION
1	-1	1	SHAFT	6061 T6	01	1	-1	1	SHAFT
1	-2	1	BEARING CUTTER TOOL ASSY	6061 T6	01	1	-2	1	BEARING CUTTER TOOL ASSY
1	-3	1	HANDLE	6061 T6	01	1	-3	1	HANDLE
1	-7	1	CUTTER	6061 T6	01	1	-7	1	CUTTER
1	-10	1	SPRING	6061 T6	01	1	-10	1	SPRING
2	-11	1	WASHER	6061 T6	01	2	-11	1	WASHER
1	-13	1	BEARING	6061 T6	01	1	-13	1	BEARING
1	-15	1	KNOB	6061 T6	01	1	-15	1	KNOB
1	-16	1	REMOVAL & INSTALLATION TOOL ASSY	6061 T6	01	1	-16	1	REMOVAL & INSTALLATION TOOL ASSY
1	-17	1	R&I ADAPTER	6061 T6	01	1	-17	1	R&I ADAPTER
1	-19	1	SNAP RING	6061 T6	01	1	-19	1	SNAP RING
1	-21	1	CAP	6061 T6	01	1	-21	1	CAP
1	-23	1	BEARING	6061 T6	01	1	-23	1	BEARING
2	-25	1	WASHER	6061 T6	01	2	-25	1	WASHER
1	-27	1	BOLT	6061 T6	01	1	-27	1	BOLT
1	-29	1	BEARING	6061 T6	01	1	-29	1	BEARING
1	-31	1	WASHER	6061 T6	01	1	-31	1	WASHER
1	-33	1	BEARING	6061 T6	01	1	-33	1	BEARING
1	-35	1	WASHER	6061 T6	01	1	-35	1	WASHER
1	-37	1	BOLT	6061 T6	01	1	-37	1	BOLT
1	-39	1	BEARING	6061 T6	01	1	-39	1	BEARING
1	-41	1	WASHER	6061 T6	01	1	-41	1	WASHER
1	-43	1	BEARING	6061 T6	01	1	-43	1	BEARING
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1	-313	1	BEARING	6061 T6	01	1	-313	1	BEARING</

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

[illegible]